

Work Order ID 127360

December-17-14 1:15:07 PM

127360

Page 1

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Upper Rib Assembly
 Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-12-19 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	C

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00

100

Large Fab Memo 0.00
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564
 2- Weld bushing in rib and grind weld flush as per dwg

5x CC 15-1-22

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
 Quality Control

5x **DAS 43 9-89** JAN 23 2015

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00
 Quality Control

5x **DAS 43 9-89** JAN 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>WJF</i>	0.00							
130									
Packaging	Memo	0.00				<i>5x</i>		DAS 43 9-89	JAN 23 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				<i>MLJ</i>		<i>1501-23</i>	
Quality Control									

15.1-23

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 1

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Work Order ID: 127360

127360

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG
REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 *D4034-1* Rib		Manufactured	No			100	Each	20.0000	1	4			
** CC 15-1-22													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA004	20						
						117167	3						
						117168	8						
						117169	9						
D4034-3 *D4034-3* Rib		Manufactured	No			100	Each	5.0000	1	4			
** CC 15-1-22													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA004	5	B117127					
						117126	5						
D4021-7 *D4021-7* Hoop		Manufactured	No			100	Each	6.0000	1	4			
** CC 15-1-22													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA004	6	B127874					
						123448	6						

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

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Work Order ID: 127360

127360

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

D4021-9

Manufactured No

100

Each

154.0000

4

16

D4021-9

Bushing

**

CC 15-1-22

Location

Loc Qty

Loc Code

WA004

154

116010

44

117495

1

120334

40

121536

20

121805

1

122601

10

123427

38

5x

15x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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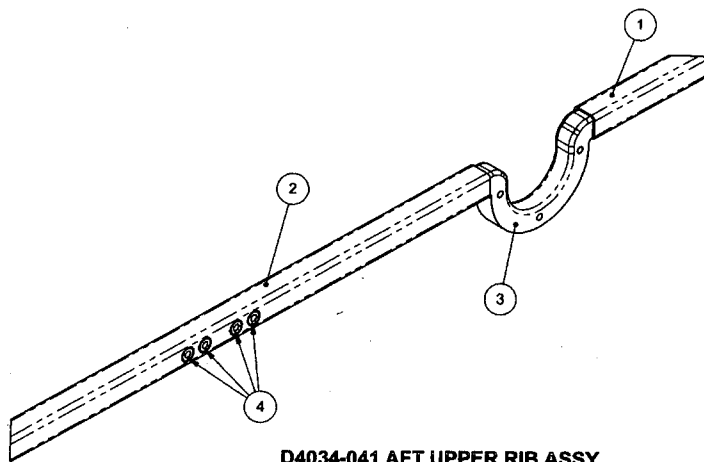
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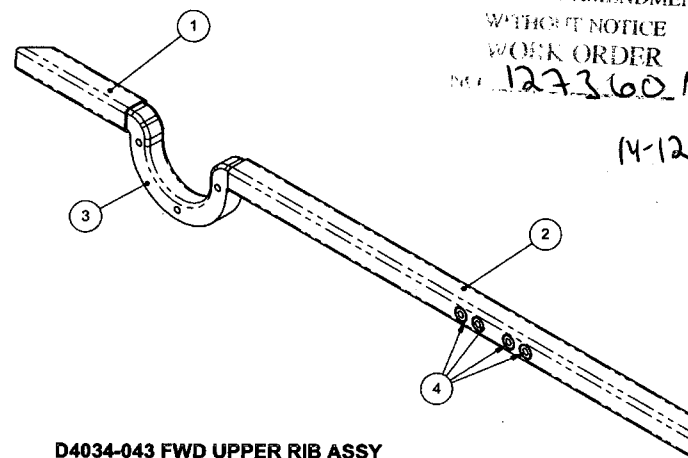
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



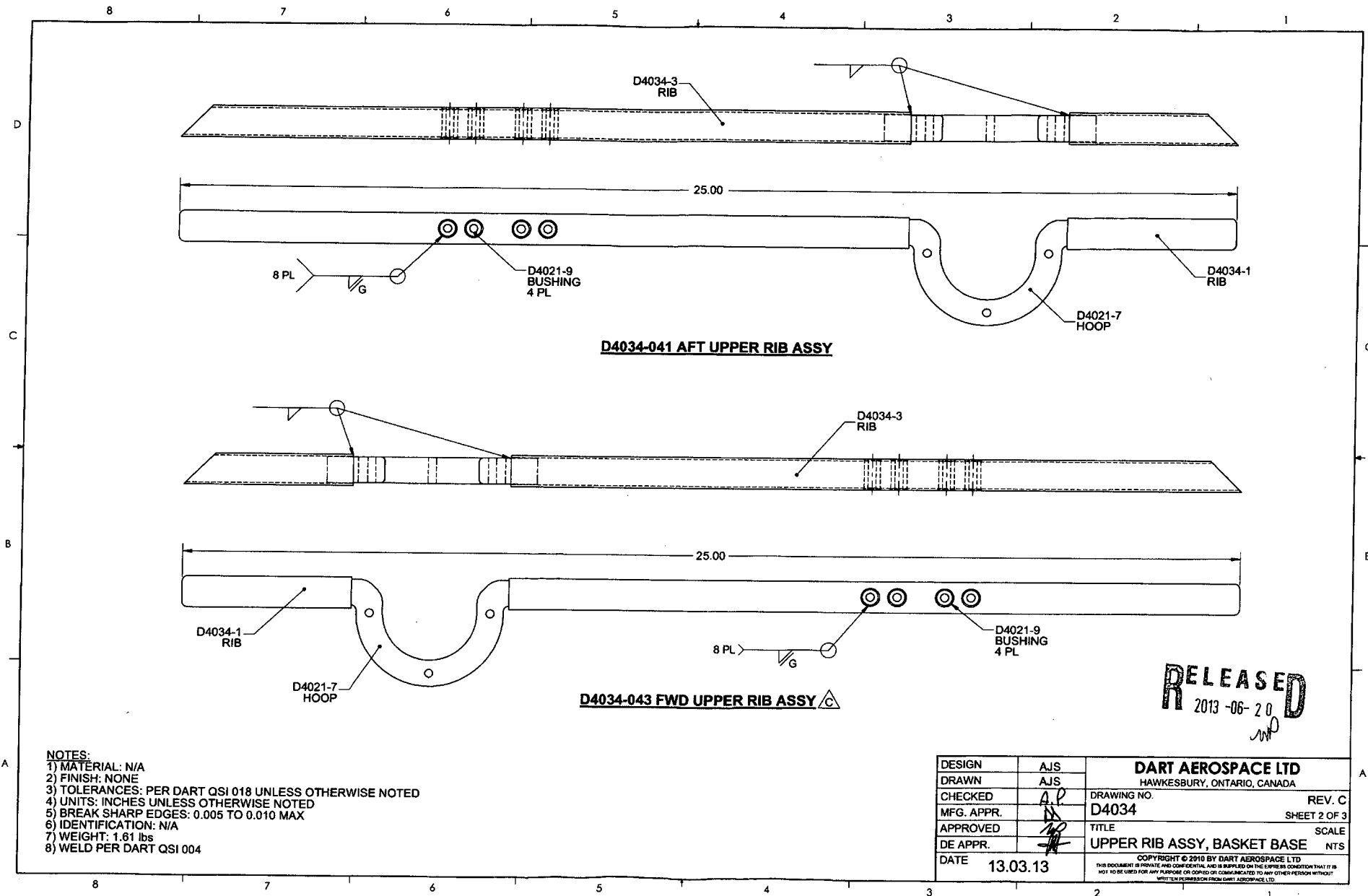
D4034-043 FWD UPPER RIB ASSY

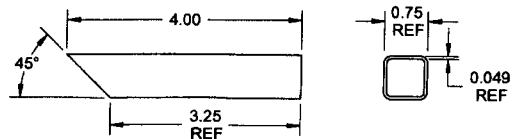
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 127360 MJS

14-12-19

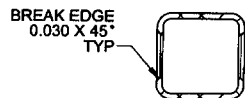
RELEASED
2013-06-20

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.		AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB		SC	10.12.20
A	NEW ISSUE		AJS	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 TITLE UPPER RIB ASSY, BASKET BASE	REV. C SHEET 1 OF 3 SCALE NTS	
DRAWN	AJS			
CHECKED	A.P.			
MFG. APPR.	AS			
APPROVED	AP			
DE APPR.	AS			
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

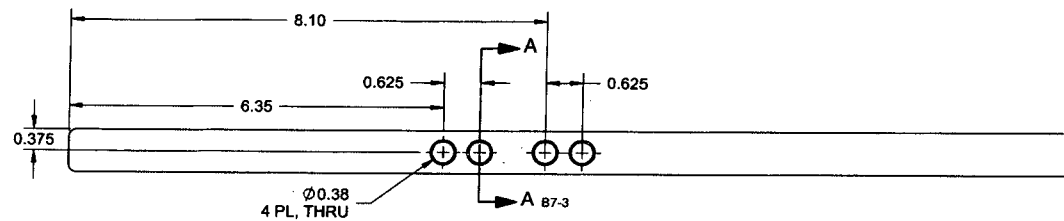




D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D4034	REV. C SHEET 3 OF 3
MFG. APPR.	AS	TITLE UPPER RIB ASSY, BASKET BASE	SCALE NTS
APPROVED	AP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	AP		
DATE	13.03.13		